D

Page 1

September 1, 2009 10:53:19 AM

Item ID:

D3186-3

**Revision ID:** Item Name:

Spacepod Door, LH

**Start Date:** 

9/01/09

Start Oty: 1.00

Req'd Qty: 1.00

Accept

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Required Date: 9/11/09

QC:

Date:

Date: **Tooling:** 

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Setup Start

Stop

Sequence ID/ **Work Center ID**  Operation **Description** 

Set Up/ **Run Hours**  Draw Number

Draw Rev.

Plan Accept Qty Code

Reject Qty

Insp. Reject Number Stamp

Draw Nbr

**Revision Nbr** 

D3186 Rev D

100

Small Fab

Small Fab

Small Fab

Memo

1-Drill holes and cut out latch slots per dwg D3186 (D3186-3 detail)

110

**Quality Control** 

QC5- Inspect part completeness to step on W/O

0.00

0.00

0.00

120

Identify as per dwg & Stock Location: 0.00

Packaging

Packaging

Memo

Memo

0.00

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
9/9/9	100	Cut latch sluts at 1.10 edge distance instead of 0.98.	04,04	·		6. vs. is 85, 492	orlolog		
						·			

Part No:		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Approval	Approval QC Inspector			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng				
							ī.				
<del></del>											
								5			

#### Work Order ID 51746

September 1, 2009 10:53:19 AM

Page 2

Item ID:

D3186-3

D **Revision ID:** 

Item Name:

Spacepod Door, LH

**Start Date:** 

9/01/09

Start Qty: 1.00

Required Date: 9/11/09

Req'd Qty: 1.00

Accept

Setup Start



Stop

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

**Process Plan:** 

Date:

Date:

**Tooling:** 

Date:

Run

Start

Stop

SPC (Y/N):

Set Up/

Run Hours

Date:

Sequence ID/ **Work Center ID** 

130

QC:

QC21- Final Inspection - Work Order Release

Operation Description

Memo

Draw Draw Plan Number Rev. Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

0.00 0.00

Quality Control

u 99-09-41

W/O:			W	ORK ORDER CHANC	GES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
. ,			10.0.							
Part No:		PAR #: Fault Category:				: Yes N	lo DQ	<b>A</b> :	Date:	150-2-
Resolution:										
NCR:			WORK ORE	ER NON-CONFORM	ANCE	(NCR)	ı			
DATE	STEP	Description of NC	Corrective Action S Initial Action Description		tion B	Sign &	- Verification		Approval	Approval
		Section A	Chief Eng	Chief Eng		Date	Section	on C	Chief Eng	QC Inspector
								!		
	9									
			-							

September 1, 2009 10:53:18 AM

Work Order ID: 51746

Parent Item:

D3186-3RevD

Parent Item Name: Spacepod Door, LH

Comments:

Component	Item	ID/	Rep
Item Name			Iter

placement Mfg/ m ID Purch

Last

**Start Date: 9/01/09** 

Required Date: 9/11/09

Start Qty: 1.00

Required Qty: 1.00

Remaining	Qty	Date	Status
Qty To Pick	Issued	Issued	Junear

Manufactured

Item No

Bin

Seq ID Location

Route

Measure Each

Unit of

Hand 1.0000

Qty on

1.0000

ZT 09.09.09

Page 1

Loc Qty

Location

Main Warehouse

ST

Warehouse

45690A

Loc Code

48149 001

**Picklist Print** 

Primary

Location

D3186-1MRevD SPACEPOD DOOR LH

		<del></del>								
W/O:			WORK ORDER CHANGES							
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
				·						
			•							
		PAR #:	Fault Cate	egory:	_ NCR: Yes	No De	QA:	Date:		
	Re	esolution:	Disposition: QA			Closed: _		Date: _		
NCR:		,	WORK ORD	ER NON-CONFORMA	ANCE (NC	R)				
DATE	STEP	Description of NC	Corrective Action Section B			Veri	fication	Approval	Approval	
	0121	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		ction C	Chief Eng	QC Inspector	
								i.		

0407	DESIG	S,	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DART	CHEC	KED	APPROVED	D3186 SHEET
	DATE 07.0	02.22		TITLE SPACEPOD DOOR
	A		03.03.27	NEW ISSUE
MAIN LAYUP 9 OZ SATIN (9 SQ FEET) 9 OZ SATIN (9 SQ FEET)	В		06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED
FOAM	С		06.12.13	REMOVED DO600-XXX LABELS
9 OZ SATIN (9 SQ FEET) 12 OZ UNIDIRECTIONAL	D		07.02.22	UPDATE DIMENSIONS
9 OZ SATIN (9 SQ FEET) RESIN (35–45% BY WEIGHT) PEEL PLY				RELEASED
ROUTER FOAM TO ROUTER PATTERN D3186-1T1 (P/N D3186-101)  REFER TO DETAIL 'B' FOR SHAPE (4 PLACES)  5.5			0.2 0 (TYP)	REFER TO DETAIL 'A' FOR SHAPE (3 PLACES)  5.5  3.4
12 OZ UNIDIRECTIONAL 4.5" WIDE ALONG OUTSIDE EDGE <u>D3</u>	<u> 186–</u>	1M SP#	CEPOD DO	OR AS MOLDED

REV. D 1 OF 5 SCALE

#### **NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
  - 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

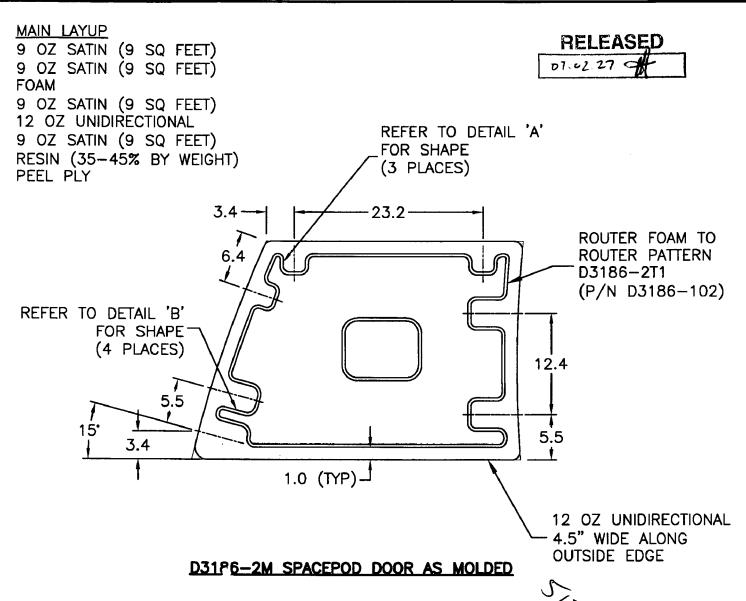
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W/O:			WO	RK ORDER CHANG	ES		,			
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No: PAR #:		PAR #:	Fault Cate	Jory:	_ NC	R: Yes	No <b>DQ</b>	A:	Date:	
NCR:		\	WORK ORDE	R NON-CONFORM	ANCE	(NCF	R)	<del></del>		
DATE	CTED	TEP Description of NC Section A			ion B			cation	Approval	Approval
DAIL	SIEP		Initial Chief Eng	Action Description Chief Eng		Sign 8 Date		Section C	Chief Eng	QC Inspector
:										
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DESIGN DS	1	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED	$\neg$	APPROVED 11	DRAWING NO.	REV. D
	冉		D3186	SHEET 2 OF 5
DATE			TITLE	SCALE
07.02.2	22		SPACEPOD DOOR	NTS



#### NOTES:

1) USE MOLD DT8006 FOR DOOR LAYUP

2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL

4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")

12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")

- 5) LAMINATE PER DART QSI 006 4.0
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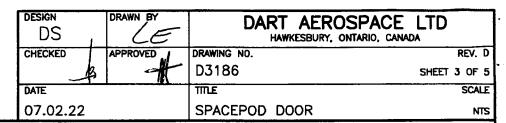
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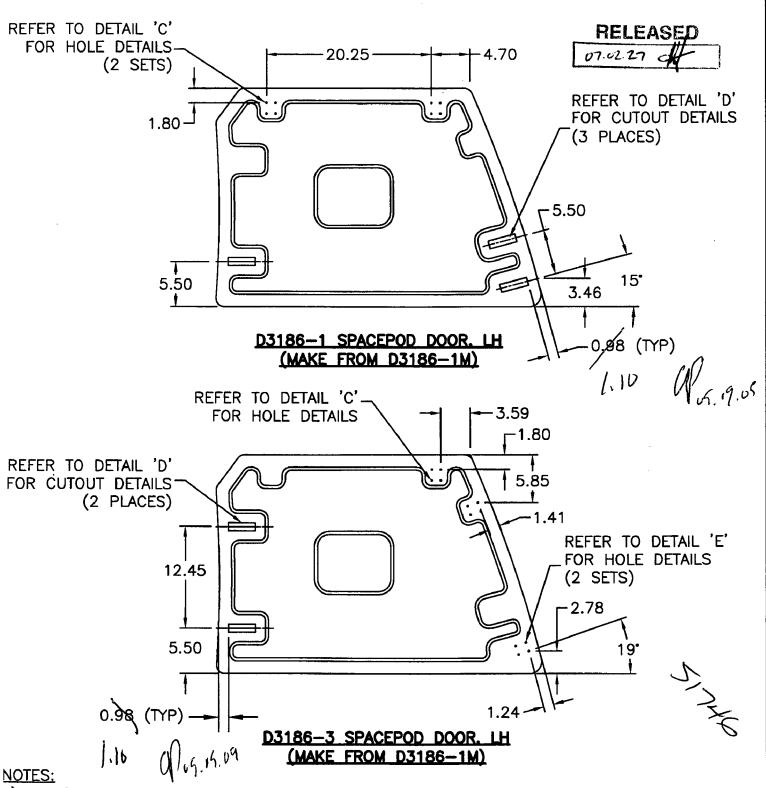
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DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
7										

Part No:		PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed	<u>•</u>	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B			Annuaral				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
		<u></u>									
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1) ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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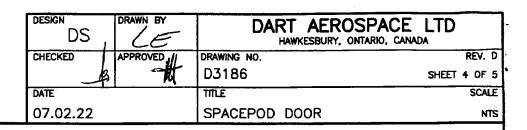
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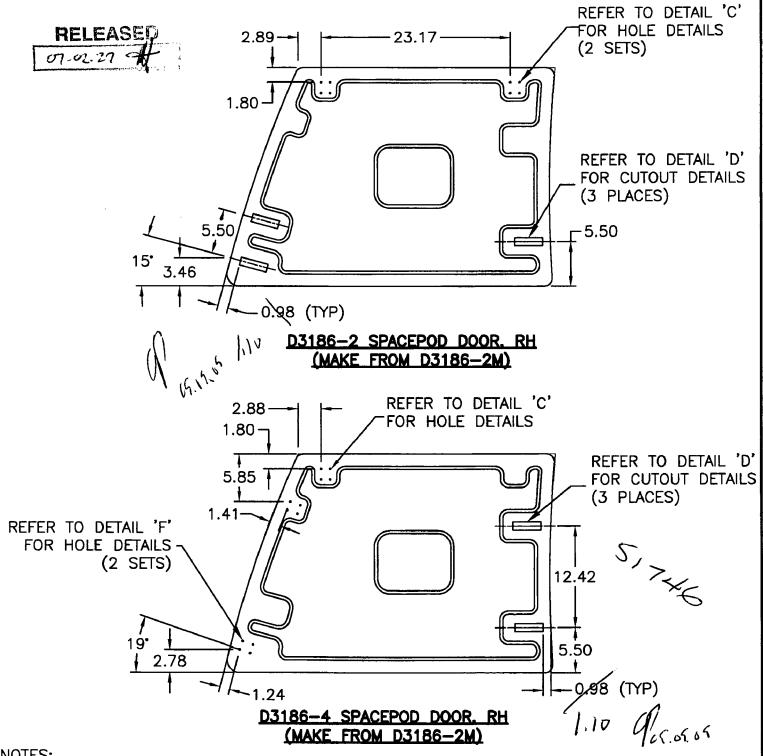
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Part No	:	PAR #:	Fault Category:	NCF	R: Yes	No <b>DQ</b>	<b>A</b> :	_ Date: _	
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC	Corrective Action Section B			Verification	<b>A</b>	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
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- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

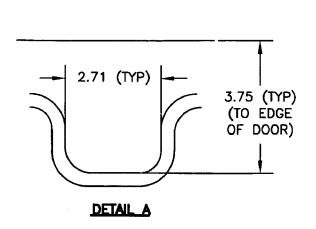
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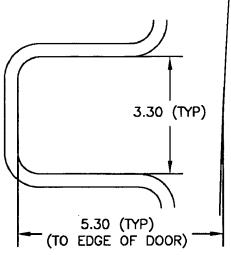
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W/O:	•		W	ORK ORDER CH	ANGES		-			
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				<del></del>						
	-									
Part No	:	PAR #:	Fault Cat	egory:	NC	R: Yes	No <b>DQ</b>	A:	Date: _	
	R	esolution:	Dispositi	on:	Q <i>A</i>	: N/C C	Closed:		Date:	
NCR:		W	ORK ORE	DER NON-CONFO	RMANC	E (NC	R)			
DATE	CTED	Description of NC			Section B	Verifica		cation	n Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	tion	Sign Date	&   Sect	ion C	Chief Eng	QC Inspector
										2



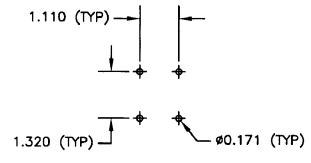
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-	CHECKED	APPROVED.	DRAWING NO.	REV. D
ı		1	D3186	SHEET 5 OF 5
ı	DATE		TITLE	SCALE
	07.02.22		SPACEPOD DOOR	NTS

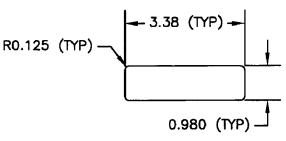




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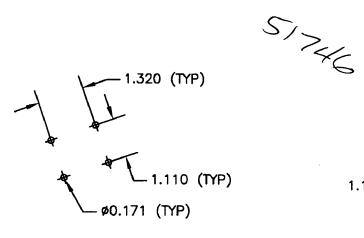
DETAIL B



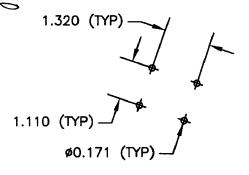


DETAIL C

NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR



# <u>DETAIL D</u>



#### DETAIL E

**DETAIL F** 

#### NOTES:

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- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER C	HANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
	:						
Part No	:	PAR #: Fault Category:	<b>NCR:</b> Ye	s No <b>DQ</b>	A:	Date:	

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:		,	WORK ORDE	ER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B			Verification Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
						and to the		
NOTE	ate & initial	all entries						
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